

ABSTRACT OF THE DISCLOSURE

In a screen printing method of bringing a mask plate into contact with a substrate to print solder cream through a pattern hole on the substrate, a plate separating operation 5 of separating the substrate from the mask plate after a squeegeeing step in which the solder cream is filled into the pattern hole comprises an operation pattern in which acceleration and deceleration pattern in which a descending speed is accelerated up to an upper limit speed and thereafter decelerated 10 up to a lower limit speed is repeated plural times. Further, an initial upper limit speed in start of the plate separating operation is set higher than the succeeding upper limit speeds, whereby viscosity of the solder cream into the pattern hole in start of the plate separating operation is lowered, and 15 the mask plate can be separated with a high accuracy throughout the entire range of the substrate.